

Amendments to the Specification:

Please replace the paragraph beginning on page 4, line 4, with the following rewritten paragraph:

The surface of the ornamental portion formed of vulcanized rubber is formed into an irregularly roughened surface due to the combination of the many fine microcapsules thermally expanded therein, the concave portions formed due to the burst of microcapsules provided on or in the vicinity of the surface, and the projection portions formed due to the swelling of the microcapsules provided on the surface. Thus, the ornament member provides an appearance closely resembling that of an actual woven cloth. The plural longitudinal or lateral convex ridges and/or the longitudinal or lateral concave grooves are formed on such a roughened surface of the ornamental portion in such a way as to extend along the longitudinal or lateral direction thereof. ~~This~~ ~~These~~ longitudinal or lateral convex ridge ridges and/or the longitudinal or lateral concave ~~groove~~ grooves are interrupted or deformed due to the interference by the concave portions and/or the projection portions, because of which the surface of the ornamental portion is formed into the roughened surface. The monotonous linearity of the longitudinal or lateral convex ridge and/or the longitudinal or lateral concave groove is changed, so that a surface pattern having fine ups and downs is formed. Consequently, the surface of the ornamental portion provides an appearance closely resembling that of a woven cloth, so that the decorativeness thereof is enhanced. Also, the ornamental portion, whose surface providing an appearance, which closely resembles that of a woven cloth, is formed integrally with the attaching portion.

Please replace the paragraph beginning on page 8, line 5, with the following rewritten paragraph:

Furthermore, according to a ninth aspect of the invention, in the member according to one of the first to eighth aspects, a depth of the concave groove in the ornamental portion is limited within a thickness of the ornamental portion. Thus, the ground color of the attaching portion is not exposed. The entire ornamental portion can provide an appearance closely resembling that of an actual woven cloth.

Please replace the paragraph beginning on page 8, line 12, with the following rewritten paragraph:

Further, according to a tenth aspect of the invention, in the member according to one of the first to ninth aspects, the concave grooves in the ornamental portion have V-shaped cross section. Thus, the visibility of the concave grooves in the surface of the ornamental portion is high, so that the appearance of the surface of the ornamental portion can be provided in such a way as to be close to that of an actual woven cloth.

Please replace the paragraph beginning on page 10, line 11, with the following rewritten paragraph:

Further, according to a seventeenth aspect of the invention, in the member according to the fifteenth or sixteenth aspect, the modified layer is a silicone resin coat. Thus, in addition to the advantages and effects of the fifteenth or sixteenth aspect, the wear-resistance and the weather-resistance of the member can be enhanced still more.

Please replace the paragraph beginning on page 17, line 17, with the following rewritten paragraph:

Further, according to a twenty-eighth aspect of the invention, in the method according to one of the twenty-fifth or twenty-sixth to twenty-seventh aspect, the predetermined ornamental-portion forming part is extruded in a state in which the microcapsules are not burst. Because the many microcapsules provided in the predetermined ornamental-portion forming part partly burst during a state in which no pressure acts on the surfaces thereof after the extrusion, so that an uneven pattern is formed on the surface of the ornamental portion, the uneven pattern can easily be formed on the surface of the ornamental portion.

Please replace the paragraph beginning on page 18, line 18, with the following rewritten paragraph:

Further, according to a thirtieth aspect of the invention, in the method according to the twenty-sixth- twenty-ninth aspect, before completion of vulcanizing the unvulcanized rubber of the predetermined ornamental-portion forming part, at least softening and expansion of the outer shell of the microcapsule are finished. Because the vulcanization is performed after the uneven pattern due to the burst of the microcapsule is formed on the surface of the predetermined ornamental-portion forming part, the expansion and the burst of the microcapsules are not restricted or prevented.

Please replace the paragraph beginning on page 28, line 22, with the following rewritten paragraph:

The microcapsules 6 mixed and kneaded in the materials of the ornamental portion 3 has a thermo-expandable outer shell that is thermoplastic and softens and becomes

expandable during being heated. The outer shell softens at a predetermined heating temperature, and the involved gas is volume-expanded. This is followed by the microcapsules that finally swell outwardly in the vicinity of the surface of the ornamental portion 3. The outer shell of the ~~ornamental portion 3~~ microcapsule 6 exceeds expansion limit and bursts in the vicinity of the surface of the ornamental portion 3. Then, concave portions 6a, which are outwardly opened, are formed therein (see FIGS. 9 to 11). Thus, fine uneven patterns are shaped on the surface of the ornamental portion 3. According to this embodiment, when the weather strip W₄, ~~which~~ W₁' ~~which~~ is in the process of vulcanizing, is heated, the outer shells of the microcapsules 6 are heated by heat given for vulcanizing the unvulcanized rubber. Thus, the outer shell thereof is softened and swelled and burst, as described above. That is, in the case that the predetermined ornamental-portion forming part 3' made of unvulcanized rubber is heated, and that the Mooney viscosity of the predetermined ornamental-portion forming part 3' is lowered by the heating, as compared with that measured before being heated, at least the softening and the expansion of the outer shells of the microcapsules are started. Some of the outer shells, which are not covered by the surrounding material, are heated up to a temperature at which the outer shells are burst by the increased internal pressure of the gas. Then, at least the softening and the expansion of the outer shells of the microcapsules are finished before the vulcanization of the unvulcanized rubber of the predetermined ornamental-portion forming part 3 is completed. Thus, it is necessary for the preferred microcapsules 6 of this embodiment that an explosion temperature thereof, which is sufficient for causing the outer shell to soften, melt, and explode, is higher than an extrusion molding temperature of the material M₃ of the predetermined ornamental-portion forming part 3' extruded from the rubber extrusion die F (to be described later) and is lower than a vulcanizing temperature of the material M₃ (it is preferable that the outer shell of the microcapsule 6 does not burst when the predetermined ornamental-portion forming part 3'

is extruded, and that the outer shell thereof is burst and/or expanded when the vulcanization thereof is performed by being heated). Concretely, the outer shell of the microcapsule 6 starts to soften and expand at a temperature of about 120 °C. Preferably, the explosion temperature thereof is equal to or higher than 150 °C and equal to or lower than 200 °C. Incidentally, for example, EXPANCEL Microsphere (sold by Japan Ferrite Co., Ltd.) and Matsumoto Microsphere (sold by Matsumoto Yushi Co., Ltd.) can be used as such a thermo-expandable microcapsule. Preferably, the compounding ratio of the microcapsules 6 to the material of the ornamental portion 3 by mass is equal to or more than 0.1 % by mass and equal to or less than 5 % by mass.

Please replace the paragraph beginning on page 30, line 25, with the following rewritten paragraph:

As shown in FIGS. 1 to 4, an end plate 11 is included in the rubber extrusion die F. In the end plate 11, an orifice (or extrusion opening) 12, whose shape corresponds to that of a cross section of the weather strip W₁', which is in the process of molding, is formed. Material extruders A₁, A₂, and A₃ for extruding materials, which are used for forming the predetermined attaching-portion forming part 1', the predetermined seal-portion forming part 2', and the predetermined ornamental-portion forming part 3' of the weather strip W₁', are connected to the rubber extrusion die F (see FIG. 1). The materials are supplied from different parts of the rubber extrusion die F to inner material paths separated from one another. Then, the materials join together at an upstream side part of the orifice 12. Thus, the weather strip W₁' is extruded from the orifice 12. A metal core 4 to be embedded in the predetermined attaching-portion forming part 1' is drawn out of a metal core supply uncoiler B. Subsequently, the metal core 4 is roll-formed by a metal core roll-forming machine C in such a way as to have a roughly reversed-V-shaped cross section. Then, the roll-formed

metal core 4 is supplied into the rubber extrusion die F, and guided by a metal core guide 13 provided therein, so that the metal core 4 is integrally embedded in the predetermined attaching-portion forming part 1' in the rubber extrusion die F. Incidentally, in FIG. 4, reference characters M₁ and M₃ designate materials that are present in the molding die F and respectively used for forming the predetermined attaching-portion forming part 1' and the predetermined ornamental-portion forming part 3'. The material for forming the predetermined seal-portion forming part 2' is not shown in this figure. Moreover, in FIG. 3, reference numeral 20 denotes a part of a molding die that is a central core mold, which is disposed in the orifice 12, for forming the predetermined hollow seal-portion forming part 2' in such a way as to be hollow.

Please replace the paragraph beginning on page 31, line 13, with the following rewritten paragraph:

At the downstream side of the orifice 12 of the rubber extrusion die F, the lateral concave groove providing roller R for forming, just after the extrusion, the lateral concave grooves 8 in the surface of the predetermined ornamental-portion forming part 3' is disposed. Preferably, the roller R is driven and rotated in a direction of an arrow E at a circumferential speed that is equal to the extrusion speed of the weather strip W₄, ~~which~~ W₁', which is extruded from the orifice 12 of the rubber extrusion die F and in the process of extrusion molding. Alternatively, the roller R may be rotated from an idling and non-driven state in such a way as to follow the extrusion of the weather strip W₄, ~~The~~ W₁'. The cross sectional shape in an axial direction of the surface of the roller R is set to be gently corrugated shape corresponding to the shape of the surface of the predetermined ornamental-portion forming part 3'. Many projections 16 are formed on the outer peripheral surface of the roller R in such a way as to extend in parallel with one another along the axial direction. The interval

and the projection height of the many projections 16 are almost equal to those of the convex ridges 15. Incidentally, the interval and the projection height of the projections 16 may be different from those of the convex ridges 15. Further, as shown in FIGS. 2 to 4, a supporting device 17 for supporting a pressing force of the roller R by supporting a part of the predetermined ornamental-portion forming part 3' and the predetermined attaching-portion forming part 1' by sandwiching is disposed just under the lateral concave groove providing roller R. The supporting device 17 is fixed to a front end surface of the end plate 11 through plural fixing bolts 18. The shape of the top surface 17a of the supporting device 17 is the same as that of the bottom surface (the rear surface) of the predetermined attaching-portion forming part 1' provided on the rear surface of the predetermined ornamental-portion forming part 3'. An insertion hole 17b, through which a part of the predetermined attaching-portion forming part 1' can be passed, is formed in the supporting device 17. This insertion hole 17b is opened therein in such a way as to gradually and upwardly decrease the width thereof.

Please replace the paragraph beginning on page 35, line 23, with the following rewritten paragraph:

Next, the method of manufacturing the weather strip W_4^2 W_1 of the aforementioned configuration by using the rubber extrusion die F of the aforementioned constitution is described. As shown in FIGS. 1 to 4, different materials (that is, the EPDM material used for forming the predetermined ornamental-portion forming part 3' and obtained by kneading the microcapsules and the vulcanizing agent and other additives, the EPDM material used for forming the predetermined attaching-portion forming part 1' and obtained by kneading the 20% to 40% carbon black by mass and the vulcanizing agent, and the EPDM material used for forming the predetermined hollow seal portion and obtained by kneading the 20% to 40% carbon black by mass, the vulcanizing agent, and a foaming agent) are supplied from the

material extruders A_1 , A_2 , and A_3 to different material paths separated from one another in the rubber extrusion die F . The three different kinds of materials join together at the front side (the upstream side) of the end plate 11 and then are extruded from the orifice 12 as the weather strip W_1' , which is in the process of extrusion. The unvulcanized rubber material, which is obtained by kneading the vulcanizing agent and the many fine expansive microcapsules 6 therein, is extruded from the orifice 12, so that the predetermined ornamental-portion forming part 3' is formed in a layer on the surface of the predetermined attaching-portion forming part 1' in such a way as to be integral therewith. Further, the rubber material constituting the predetermined ornamental-portion forming part 3' is extruded from the orifice 12 in a state in which as shown in FIGS. 4 and 5, the plural substantially-V-shaped longitudinal concave grooves 7 are simultaneously formed on the surface of the predetermined ornamental-portion forming part 3' in such a way as to be parallel to one another by the plural projections 15 formed on the extrusion surface 14 of the orifice 12. According to the invention, the weather strip W_1' , in which only the longitudinal concave grooves 7 (or only the longitudinal convex ridges 9 (to be described later)) are formed, may be supplied for the next vulcanizing process. However, according to this embodiment, patterns, which more closely resemble that of an actual woven cloth, are formed, by forming the lateral concave grooves 8 using the lateral concave groove providing roller R , which will be described herein.

Please replace the paragraph beginning on page 37, line 13, with the following rewritten paragraph:

The predetermined ornamental-portion forming part 3' of the weather strip W_1' , which is in the process of molding, is extruded in a state, in which the plural longitudinal concave grooves 7 are formed in the surface thereof, from the orifice 12. Just after extrusion,

the predetermined ornamental-portion forming part 3' is sandwiched by the top surface 17a of the receiving device 17 and the lateral concave groove providing roller R disposed just above the top surface 17a and thus pushed against the top surface 17a of the receiving device 17 by a downward pushing force of the lateral concave groove providing roller R. The lateral concave groove providing roller R is driven and rotated at a circumferential speed, which is equal to the extrusion speed in the extrusion direction Q of the weather strip W₁', which is in the process of molding. Therefore, in the surface of the predetermined ornamental-portion forming part 3', other lateral concave grooves 8 are formed in such a manner as to intersect with the plural already formed longitudinal concave grooves 7, and as to continuously extend in the direction of width thereof and as to intermittently extend in the longitudinal direction (see FIG. 7). Consequently, as illustrated in FIG. 7, the earlier formed longitudinal concave grooves 7 and the later formed lateral concave grooves 8 intersect with the other kind of the grooves (when one kind of the grooves is the longitudinal concave grooves 7, the other kind thereof is the lateral concave grooves 8, whereas when one kind of the grooves is the lateral concave grooves 8, the other kind thereof is the longitudinal concave grooves 7). Thus, a surface pattern consisting of quadrangles consecutively formed in both the longitudinal direction and the lateral direction by the longitudinal concave grooves 7 and the lateral concave grooves 8, which are monotonous straight lines extending in the longitudinal and lateral directions, appears like a cross pattern woven in a cloth.

Please replace the paragraph beginning on page 38, line 21, with the following rewritten paragraph:

Incidentally, in this embodiment, the formation pitch P, the width S and the depth D of the longitudinal concave grooves 7 are equal to those of the lateral concave grooves 8, respectively, as shown in FIGs. 6 and 8. Incidentally, the formation pitch P, the width S and

the depth D of the longitudinal concave grooves 7 may be different from those of the lateral concave grooves 8. Preferably, the formation pitch P of each of the concave grooves 7 and 8 ranges from 0.1 mm to ~~2 mm~~ 5mm. In the case where the formation pitch P, the width S and the depth D of the longitudinal concave grooves 7 and the lateral concave grooves 8 are set within the aforementioned range, when the weather strip W₁' is W₁ is completed, the appearance of the quadrangular surface pattern becomes more closely resembles the actual pattern woven in the cloth. Consequently, the decorativeness thereof is enhanced. Preferably, the width S of each of the opening portions of the concave grooves 7 and 8 is smaller than the formation pitch P. Incidentally, in FIG. 6, reference character 7a designates a line of the bottom portion of the longitudinal concave groove 7. In FIG. 8, reference character 8a denotes a line of the bottom portion of the lateral concave groove 8. Further, the lines 7a and 8a can be set so that the depths thereof can be made to equal to each other. Preferably, the depths of these concave grooves remains within that of the ornamental portion in the direction of thickness thereof (that is, the depths of these concave grooves do not reach a rubber part of an attaching portion of a base).

Please replace the paragraph beginning on page 42, line 25, with the following rewritten paragraph:

Incidentally, upon completion of vulcanization, to enhance the weather-resistance and the abrasion-resistance of the predetermined ornamental-portion forming part 3', a surface modified layer 3a is formed on the predetermined ornamental-portion forming part 3' as shown in FIG. 12. Clear coating using liquid silicone or colored clear coating is performed by spray coating on the predetermined ornamental-portion forming part 3' during the weather strip W₁' passes through a surface coating machine H shown in FIG. 1. Then, the surface modified layer 3a is baked or is dried by a drier machine J. Thereafter, the weather strip

W_1' is cooled down by a cooling machine K. Upon completion of cooling, the spread reverse-V-shaped metal core 4 embedded in the predetermined attaching-portion forming part 1' is bent by a metal core bending machine (or profiling machine) L in such a way as to be reverse-U-shaped. Thus, the weather strip W_1' $\underline{W_1}$, which is a final product, is manufactured. Incidentally, in FIG. 1, reference character N designates a hauling machine for hauling the elongated weather strip W_1' , which is in the process of the molding, by applying a hauling force thereto. In FIGS. 7, 9, and 11, reference character "T" designates the direction of width of the ornamental portion 3 (3'). This also applies to other drawings.

Please replace the paragraph beginning on page 45, line 23, with the following rewritten paragraph:

Further, FIG. 15 shows an embodiment in a state in which longitudinal concave grooves and lateral concave grooves of a predetermined ornamental-portion forming part 3' are simultaneously formed by using a roller after a weather strip W_1' is extruded from a rubber extrusion die F. In this embodiment, circumferential and lateral (or axial) projections 22 and 23 are formed a concave groove providing roller R $\underline{R'}$ in such a way as to be nonlinearly corrugated and as to intersect with each other. Corrugated longitudinal and lateral concave grooves 31 and 32 are formed in the predetermined ornamental-portion forming part 3' by pressing the concave groove providing roller R $\underline{R'}$ against the surface of the predetermined ornamental-portion forming part 3' just after the extrusion in such a manner as to intersect with one another. The concave grooves 31 and 32 are constituted by curved lines, the adjacent ones of which maintain a constant interval therebetween. Thus, a pattern formed by enclosing parts of each of the concave grooves 31 and 32 is shaped like a rectangle constituted by curved lines (see FIG. 16). Incidentally, in FIG. 15, reference character 17' designates a supporting device. Further, a pattern, which more closely resembles an actual

woven cloth, can be formed on the surface by combining a rectilinear longitudinal concave groove (or convex ridge) with a curved-line-like lateral concave groove. Further, the interval of the longitudinal concave grooves (or the convex ridges) are not limited to a constant value. Furthermore, the projection heights of the projections 22 and 23 are not limited to constant values and may irregularly change. Only one of the longitudinal concave grooves (or the convex ridges) and the lateral concave grooves may be formed.